

Date: Wednesday, 1/31/2007 2:59:21 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 30538
 Estimate Number : 12579
 P.O. Number : N/A
 This Issue : 1/31/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : *N/A* Type : SMALL / MED FAB
 Previous Run : 29448
 Written By : *Jan*
 Checked & Approved By : *07.02.01*
 Comment : Est Rev: A New Issue 06-11-10 JLM

Drawing Name : ARM

Part Number : D35602
 Drawing Number : D3560 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : A
 Material : *N/A*
 Due Date : 2/7/2007

Qty: 5 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation:

1.0 M6061T6B0500X06000 6061-T6



Comment: Qty.: 1 f(s)/Unit Total: 5 f(s)

6061-T6 Bar .50" x 6.0"

Batch: *07.03.07*

2.0 WATER JET FLOW W



Comment: FLOW WATER JET

1-Cut as per Dwg D3560

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

Note: .507" Dia & .196" Dia Holes are to be opened on manual mill after Waterjet

3.0 QC2



INSPECT PARTS AS THEY COME OFF MACHINE

*mm 07 03 12**mm 07 03 07*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 MILLING CONV.



CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1-Open .196" Dia hole

2-C'Bore as per Dwg D3560.

3-Ream .507" as per Dwg D3560

Ensure to C'Bore on Corect side

*86 / DJP 07/03/08**07-03-70*

~~with weight~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3561-2 ^{NIA} PAR #: NIA Fault Category: Prod / FMS ^{NIA} ~~mod & SMT~~ NCR: Yes ~~No~~ DQA: 2 Date: 07/03/23
 QA: N/C Closed: _____ Date: _____

NCR: <u>30538</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/08	4.0	4 parts scrap C bore 0.507" is over tol. by 0.006" Can't press fit bushing	<u>08/04/08</u>	- destroy 4 parts - When doing the FAI you need to write the demension your measure (not acceptable)	<u>07/03/09</u>	<u>07/03/09</u>	<u>08/04/08</u>	<u>07/03/08</u>
				- replace 4 parts - IF FAI is not good don't to the other parts				

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 07.03.20

(4)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.03.20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA25

SA 07.03.20

4

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SA 07.03.20

(4)

Job Completion



CU-A-03-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

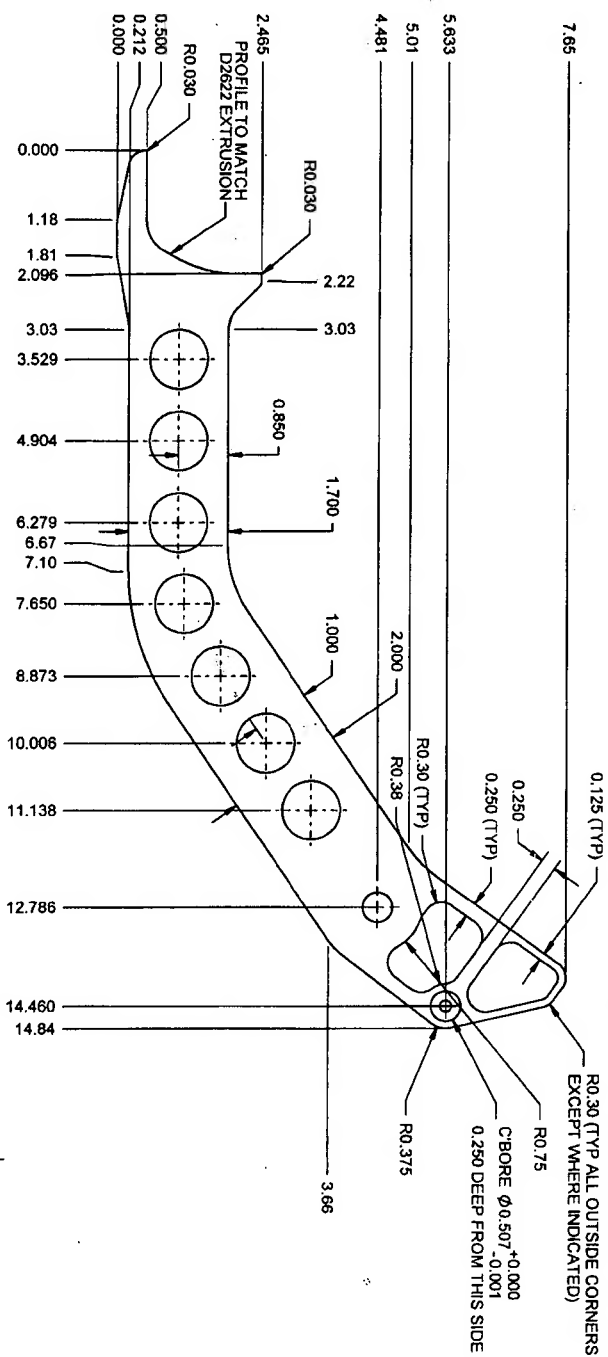
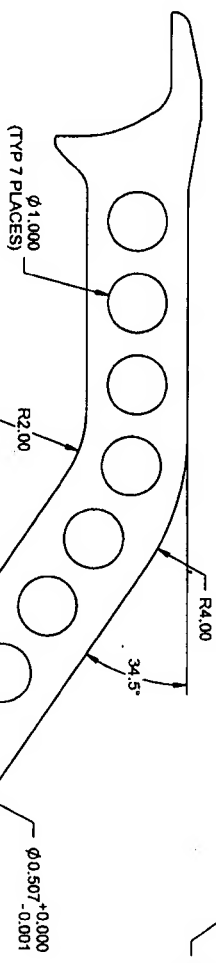
NO. 30538
WORK OFFICE
WITHOUT NOTICE
SECTION TO AMENDMENT
CONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

- NOTES:
1) MATERIAL: 6061-T6 ALUMINUM (Q-Q-A-200/8 OR Q-Q-A-250/11), 0.500 THICK
(REF PART SPEC. M6061T6B0.500)
2) FINISH: NONE
3) TOLERANCES ARE PER DART Q31 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS

Ø0.196 (DRILL #9 REF)
C:SINK Ø0.385 x 100°

Ø0.196 (DRILL #9 REF)
C:SINK Ø0.385 x 100°



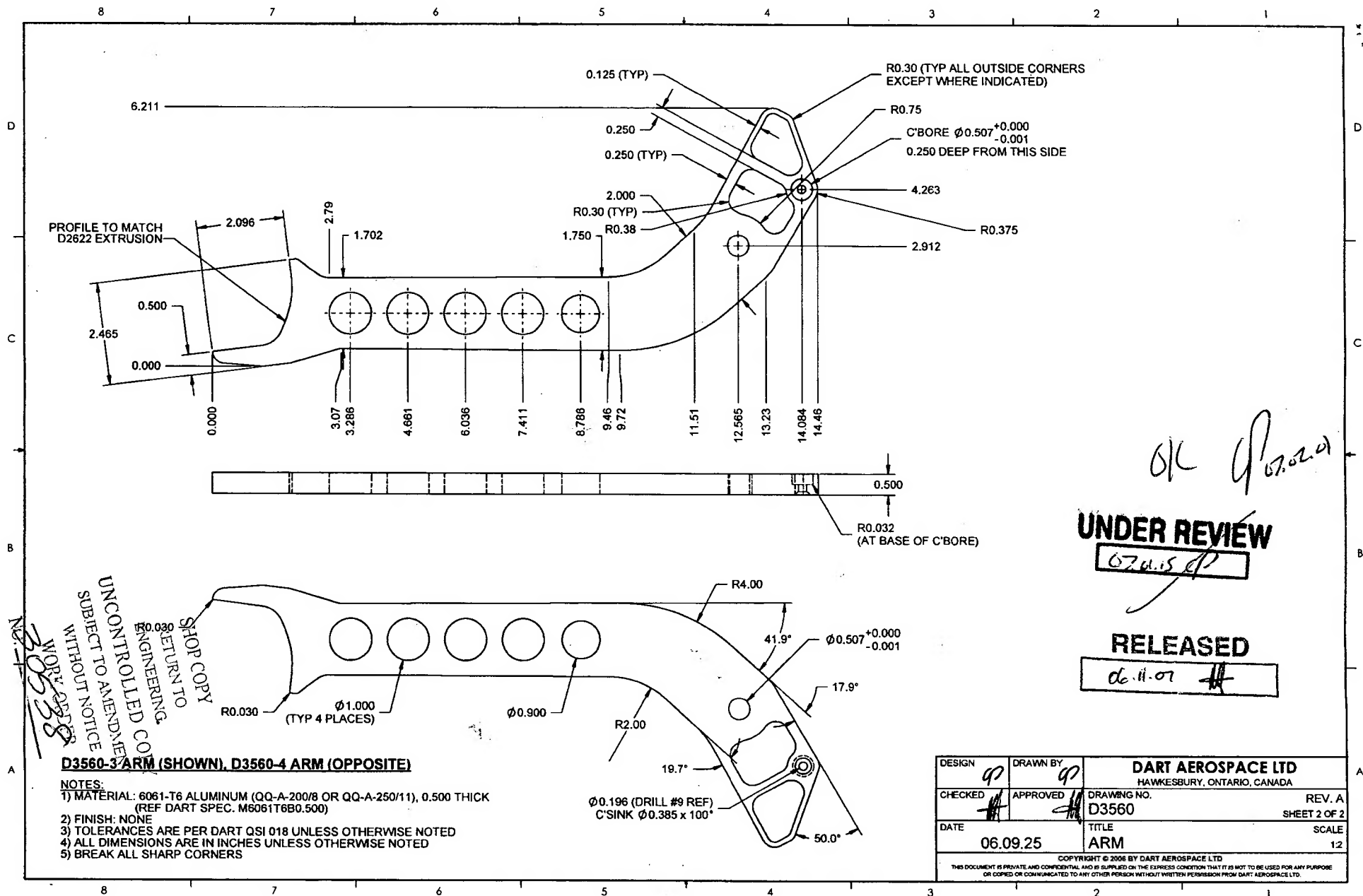
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY <i>q</i>	DART AEROSPACE LTD HARTSBURY, ONTARIO, CANADA
CHECKED <i>q</i>	APPROVED <i>q</i>	DRAWING NO. D3560
DATE	06.09.25	TITLE ARM
COPIES OF THIS DRAWING 12		REV. A SHEET 1 OF 1 SCALE

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UNDER REVIEW

RELEASED

$\alpha: 11.07$



DART AEROSPACE LTD		Work Order: 30538
Description: ARM		Part Number: D3560-2
Inspection Dwg: D3560 . Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/- 0.010	0.507	✓		vern	
2.465	+/- 0.010	2.468	✓		High Gauge	
0.250	+/- 0.010	0.255	✓		vern	
0.125	+/- 0.010	0.130	✓		vern	
1.000	+/- 0.010	1.005	✓		vern	
2.000	+/- 0.010	2.007	✓		vern	
1.700	+/- 0.010	1.707	✓		vern	
0.850	+/- 0.010	0.855	✓		vern	
0.507	+0.000 -0.001	0.507	✓			
0.250	+/- 0.010	0.252	✓			
0.385 x 100°	+/- 0.010	0.385	✓			
0.196	+0.005 -0.001	0.197	✓			
		0.513				

07/03/08

* DIP 07/03/08

Measured by: <i>[Signature]</i>
Date: 07 03 07

Audited by: <i>[Signature]</i>
Date: 07-03-20

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

